

20

DART AEROSPACE LTD	Work Order:	20701
Description: Hinge Bracket	Part Number:	D2857-2
Drawing: D2857 Rev. A	Qty:	24

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O	HJ	04.04.13	24
2	METAL	Cut blanks 5.2" Material: 2.00" X 1.25" 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8) Batch <i>M11706 M14890</i>	<i>M11706 M14890</i>		
3	HAAS	Machine per folio D2857-2	<i>M11706</i>	04.04.15	24
4	QC	Inspect Level 2	<i>M11706</i>	04.04.15	24
5	METAL	Tumble Deburr any rough edges after tumbling	<i>M11706</i>	04.04.15	24
6	METAL	Acid etch and alodine as per QSI 005 4.3	<i>M11706</i>	04.04.15	24
7	QC	Inspect Level 7	<i>M11706</i>	04.05.05	24
8	FINISHING	Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3	<i>M11706</i>	04.05.06	24
9	QC	Inspect Level 3	<i>M11706</i>	04.05.06	24
10	STORES	Identify and stock	<i>M11706</i>	04.05.06	24
11	EXPEDITING	Close W/O Cost / Part: <i>16.88</i> <i>SUE 04/05/20</i> <i>(24)</i> <i>1853</i>	<i>M11706</i>	04.05.11	24

Rev	Date	Change	Revised By	Approved
A	99.01.04	New	KS	
B	99.03.25	Added tumble and acid etch	DM	
C	00.06.22	Removed P/O for powder coat	EC	

RELEASED
JUN 26 2009

Work Order:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Manuf / Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE						
DATE	STEP	Description of NC section A	Corrective Action Section B		Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial					

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

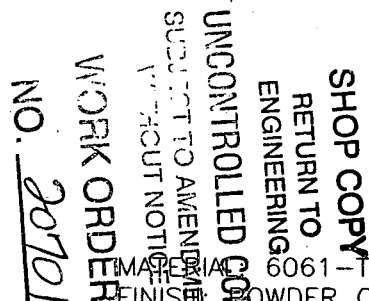
NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncB.doc

QA: N/C Closed: _____ Date: _____



DESIGN		DRAWING BY		DART AEROSPACE LTD	
CHECKED		APPROVED		DRAWING NO.	
KE		JF		D2857	
DATE		TITLE		REV. A	
98.12.14		HINGE BRACKET		SHEET 1 OF 1	
A		98.12.14		SCALE	
A1		02.04.29		1:1	
		NEW ISSUE			
		ADD THICKNESS			

49.01.06 ME



D2857-1 SHOWN
D2857-2 OPPOSITE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)
FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Apr 12, 2004
03:42 pm

Work Order No : 0020701
Project Name : D2857-2
Project For : WK420
Work Order Type : Main
Main WO Number :
House Part Number : D2857-2
Description : Hinge Bracket
Manufactured : Yes
Amount Req'd : 24
Amount Done : 0
Start Date : 04-12-04
Est Finish Date : 05-12-04
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Margin : 0.000%
Actual Margin : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

DAVID AEROSPACE LTD

Work Order:

20700

Description:

Wing Bracket

Part Number:

15857-2

Inspection By:

Rev:

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST



First Article



Prototype

Feature Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	± 0.010	4.306	✓			
.340	"	.340	✓			
1.110	± 0.005	1.109	✓			
1.790	± 0.010	1.793	✓			
1.320	± 0.005	1.319	✓			
2.000	± 0.010	2.004	✓			
0.171	± 0.008	.171	✓			
.147	± 0.010	.144	✓			
.376	"	.374	✓			
.126	"	.128	✓			
.611	"	.611	✓			
.063	"	.068	✓			
.166	± 0.008	.166	✓			
.911	± 0.010	.907	✓			
.600	"	.606	✓			
.125	± 0.010	.122	✓			
.150	"	.146	✓			

Measured by:

SP
04/10/13

Audited by:

E

Prototype Approval:

N/A

Date:

Date:

04.05.03

Date:

Rev

Date

Change

New Issue

Revised by

KJ/RF

Approved